

Date: Tuesday, 03/02/2009 11:00:13 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: AFT BASE
<b>Job Number</b>	: 45452		
<b>Estimate Number</b>	: 13036		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D365111
<b>This Issue</b>	: 03/02/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3651 REV.B
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 44675	<b>Drawing Revision</b>	: B
<b>Written By</b>	:	<b>Material</b>	:
<b>Checked &amp; Approved By</b>	: <u>JUD 09.02.03</u>	<b>Due Date</b>	: 10/02/2009
<b>Comment</b>	: Est Rev:A New Issue 07-09-27 DD verified by: EC	<b>Qty:</b>	6 Um: Each
	: Est Rev:B ECN 1113P 08-01-22 DD		
	: Est Rev:C ecn1162 08-04-02 DD verified by: ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	G89	coated cloth
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**Comment:** Qty.: 0.7203 sf(s)/Unit Total : 4.3218 sf(s)

G-89 coated cloth

Batch: 109805 HB 9-2-4

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3651

Dwg Rev: B HB 9-2-4  
 Prog Rev: B

8

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 09/02/04 (48)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and stock

Location: GA

S 29/02/04 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 03/02/2009 11:00:13 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BASE

Job Number: 45452

Part Number: D365111

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/05 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*mf 09-02-04*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: H5452
Description: Gasket		Part Number: D3651-11
Inspection Dwg: D3651	Rev: B	Page 1 of 1

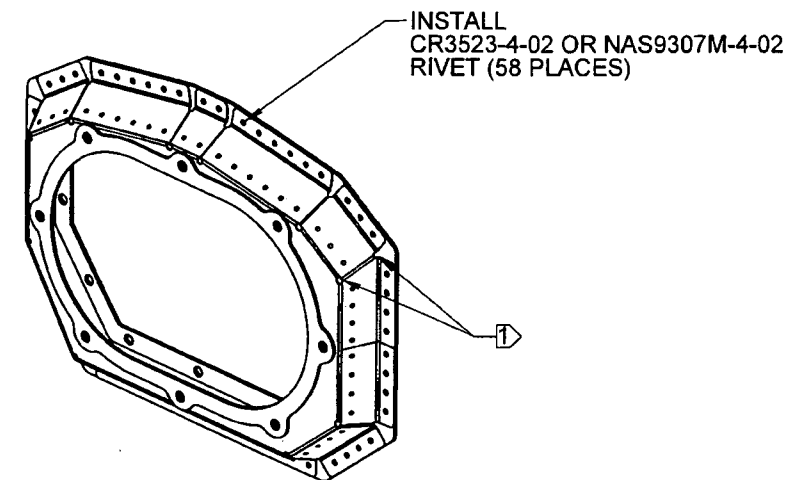
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.131	X			
Ø0.250	+0.005/-0.001	0.252	X			
8.74	+/-0.030	8.741	X			
11.62	+/-0.030	11.625	X			
1.62	+/-0.030	1.63	X			
1.41	+/-0.030	1.407	X			
0.500	+/-0.010	0.500				
0.600	+/-0.010	0.601	X			
0.634	+/-0.010	0.631	X			
2.564	+/-0.010	2.564	X			
2.081	+/-0.010	2.080	X			
3.731	+/-0.010	3.731	X			
2.100	+/-0.010	2.099	X			
9.706	+/-0.010	9.701	X			
7.969	+/-0.010	7.968	X			
6.96	+/-0.030	6.967	X			
5.698	+/-0.010	5.695	X			
3.698	+/-0.010	3.695	X			
2.564	+/-0.010	2.565	X			
2.020	+/-0.010	2.021	X			
3.284	+/-0.010	3.282	X			
2.200	+/-0.010	2.199	X			
2.750	+/-0.010	2.751	X			
9.521	+/-0.010	9.520	X			
10.22	+/-0.030	10.221	X			
1.373	+/-0.010	1.380	X			
1.62	+/-0.030	1.636	X			
3.564	+/-0.010	3.560	X			
4.236	+/-0.010	4.234	X			
5.636	+/-0.010	5.634	X			
7.049	+/-0.010	7.045	X			

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 9-2-4	Date: 09/02/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	

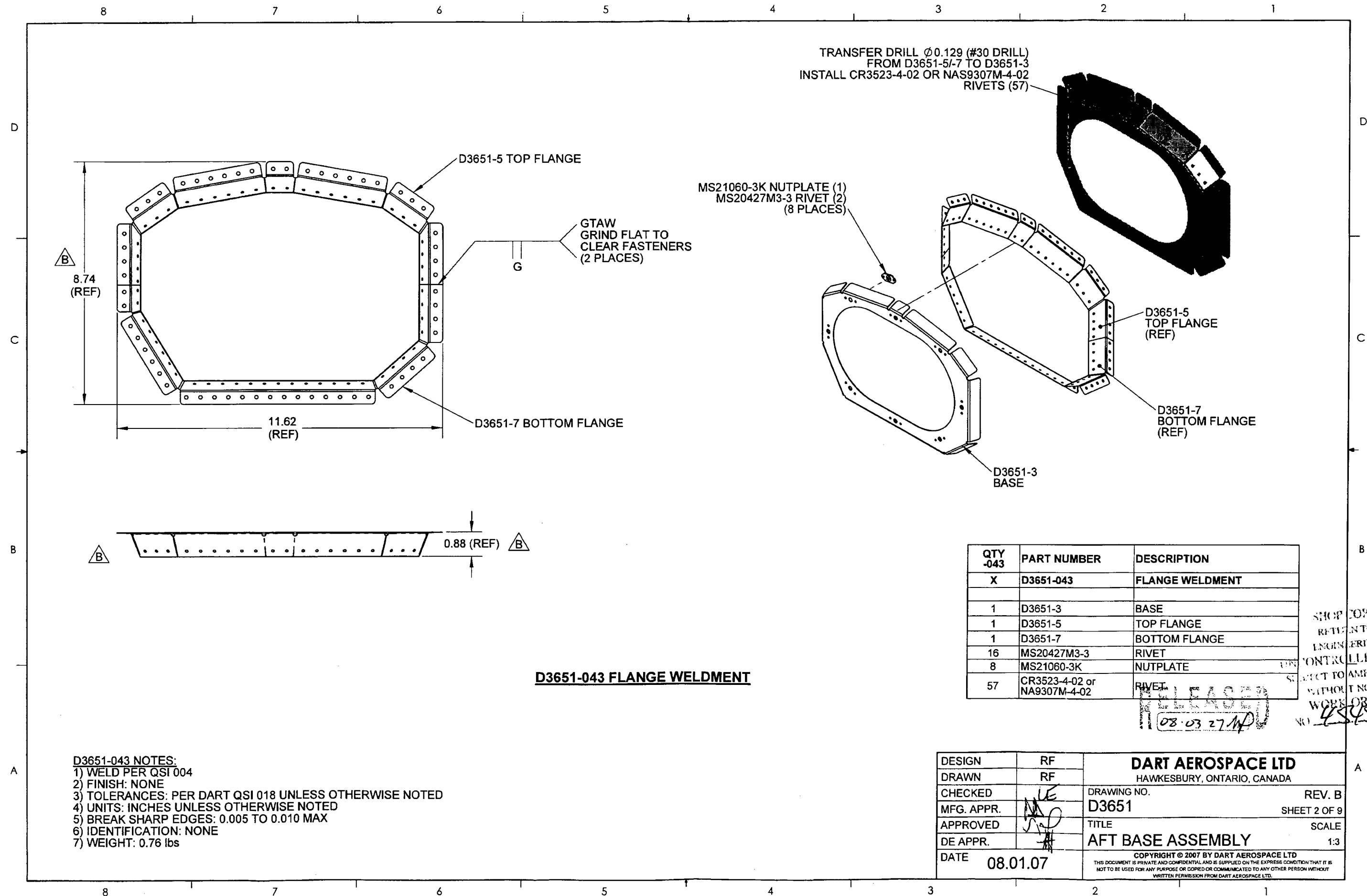


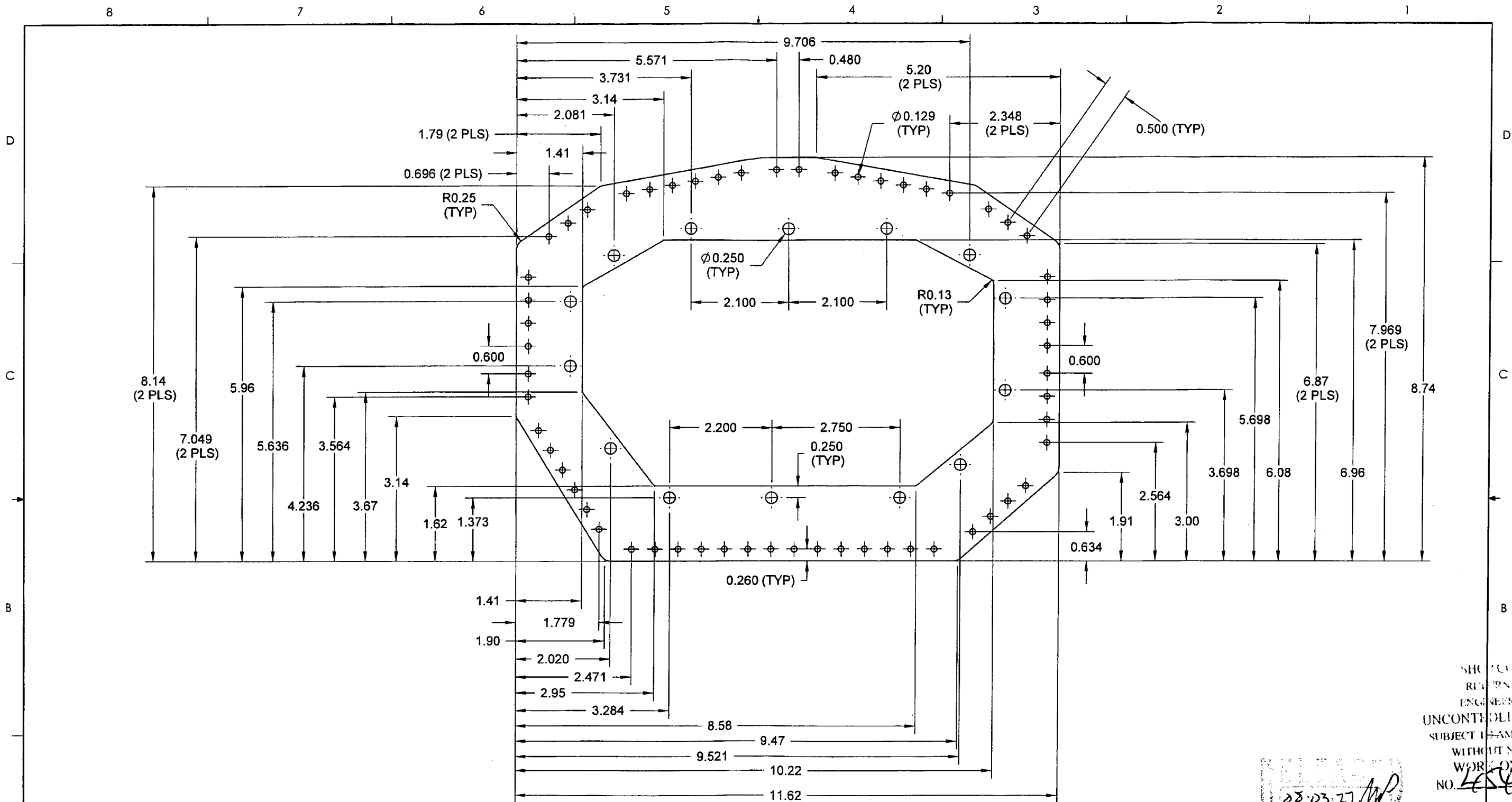
QTY -041	PART NUMBER	DESCRIPTION
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

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WITHOUT NOTICE  
WORK ORDER  
NO 45852

- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.6 lbs

B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.98; REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504		RF	08.01.07
A	NEW ISSUE		RF	07.11.07
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <span style="float: right;">REV. B</span> <b>D3651</b> <span style="float: right;">SHEET 1 OF 9</span>  TITLE <span style="float: right;">SCALE</span> <b>AFT BASE ASSEMBLY</b> <span style="float: right;">1:4</span>  COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>		
DRAWN	RF			
CHECKED	<i>[Signature]</i>			
MFG. APPR.	<i>[Signature]</i>			
APPROVED	<i>[Signature]</i>			
DE APPR.	<i>[Signature]</i>			
DATE	08.01.07			





- NOTES:
- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)  
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.2 lb

**D3651-11 GASKET** 

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	UE	DRAWING NO.	REV. B
MFG. APPR.	UE	D3651	SHEET 8 OF 9
APPROVED	UE	TITLE	SCALE
DE APPR.	UE	AFT BASE ASSEMBLY	1:2
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SUBJECT IS AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 46052